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D3294-5

Job Sheet 192235



Part No: D3294-5

Job Qty: 10 pcs

Part Name: Doubler



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/19/19

Job Tracking No:

Due Date: 4/18/19

Created By: Marie Lajeunesse

Type: ~~SOLD~~ *SOLD*

Description:

Note: DWG REV D

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	10 pcs		4/18/19	0.00	0.75	Waterjet - Flow		JRB 6/26/19
110	QC 2	10 pcs		4/18/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		JRB 6/26/19
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		

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120	QC 8	10 pcs	4/18/19	0.00 0.00	QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
130	Small Fab - Brake NC - B4B	10 pcs	4/18/19	0.06 0.54	Small Fab - Brake - 1 - B4B	JUN 27 2019 9-89 DAS 40
					Small Fab - Brake - 2 - B4B	JUL 04 2019
					Small Fab - Brake - 3 - B4B	
140	QC 5	10 pcs	4/18/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	JUL 05 2019 9-89 DAS 40
150	Handfinish - 1-1 Chemical-B4B	10 pcs	4/18/19	0.00 0.32	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	JUL 05 2019
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	

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				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	10 pcs	4/18/19	0.00 0.00	QC 21 - SA - 21	246
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-89
Part Op 110 - QC2 Waterjet-1 (QC2- Inspect parts off machine FAI/FAIB) Descriptions: 120 - QC8-2 (QC8- Inspect parts - second check) 130 - Brake NC 1 (Form as per dwg) 140 - QC5 (QC5- Inspect part completeness to step on W/O) 150 - HandFinish1 (Chemical Conversion Coat per QSI005 4.1) 160 - QC7-2 (QC7-Inspect Chemical Conversion Coat) 170 - Packaging3-1 (Identify as per dwg & Stock Location: _____) 180 - QC21 (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M2024T3S.080	2024-T3 .080 Sheet	.6500 sf (.065 ea)	100-Waterjet - Flow - 1	5137552	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Flow - 1	M2024T3S.080	1	55	0	
Part Specifications					
Specifications could not be found.					

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DART AEROSPACE LTD		Work Order: 192235
Description: Doubler		Part Number: D3294-5
Inspection Dwg: D3294	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.130	✓		VOC-02	
0.65	+/-0.030	0.65				
0.30	+/-0.030	0.30				
0.53	+/-0.030	0.52				
3.36	+/-0.030	3.35				
2.50	+/-0.030	2.50				
0.15	+/-0.030	0.15				
9.21	+/-0.030	9.22				
0.400	+/-0.010	0.401				
0.300	+/-0.010	0.300				
0.30	+/-0.030	0.30				
0.625	+/-0.010	0.625				
0.080	+/-0.010	0.081				
1.00	+/-0.030	1.00				

Measured by: JRB 6/26/19	Audited by: DAS 40 9-89	Preliminary Approval:
Date:	Date: JUN 27 2019	Date:

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	
B	13.06.03	Dwg Rev updated	KJ	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S194286



Part: D3294-5

Job No: 192235

Serial No/Batch: S194286

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 06/26/19